

Date: Wednesday, 5/23/2007 3:24:23 PM
 User: Kim Johnston

Process Sheet

SPLIT-

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32466
 Estimate Number : 10512
 P.O. Number : N/A
 This Issue : 5/23/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 32118

Drawing Name : PLUG
 Part Number : D26511 UP
 Drawing Number : D2651 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 6/6/2007

Qty: 200 Lm: Each

Written By : 07.05.24
 Checked & Approved By : 07.05.24
 Comment : Est: A 02.04.15 New Issue NG
 Est: B 05.12.12 added deburr EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar 500"



Comment: Qty.: 0.0421 f(s)/Unit Total: 8.4210 f(s) M104619 8" [7.25]
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)
 Batch: M103961 28" [2.3] RQ on the bar

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HAAS CNC VERTICAL MACHINING #1 Hardinge CNC lathe
 1- Turn as per Folio FA219 and Dwg D2651
 2- Deburr RQ MS 07/06/07

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE X 220 RQ MS 07/06/07

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK RQ 07/06/07

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr ias per dwg D2651 ml 07/06/07

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Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-07-17

(130)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Only larger section necessary)

Handwritten notes:
Spray paint
Self-etch Blue + clear
Alodine
A

(132)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

Handwritten note: stock unpacked in stores

Handwritten date: 6-7/7/17

(130)

(1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(134)

Handwritten date: 6/27/23

Job Completion



Handwritten note: U Spot 18

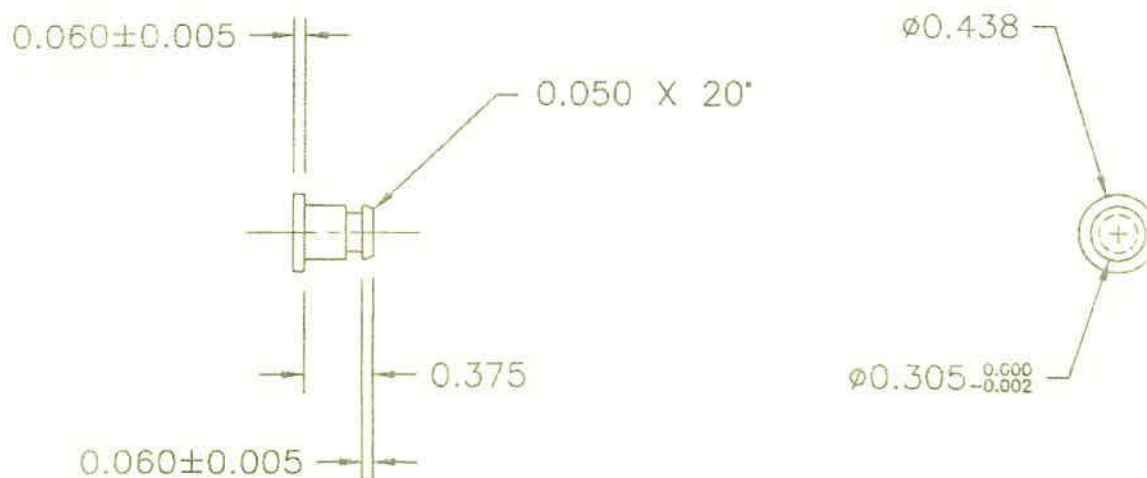


DESIGN <i>A</i>	DRAWN BY <i>A</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

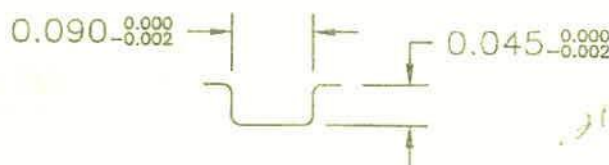
RELEASED

03.12.19 *A*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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